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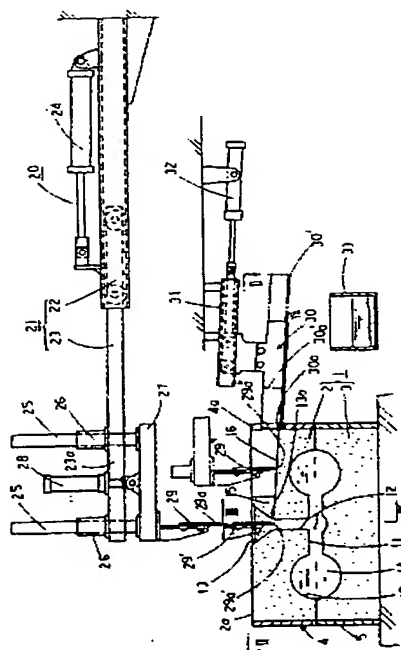
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TITLE : DIVIDING METHOD OF CASTING MOLD



ABSTRACT : PURPOSE: To permit the easy seprn. of a cope and drag and to decrease the amt. of the molding sand to be stuck to a casting and be thereby carried away in the stage of casting the casting with a casting mold divided to upper and lower parts by removing partly the wall of the sprue provided to the cope so that the molten metal in the sprue flows out.

CONSTITUTION: The molten metal is poured into the funnel-shaped sprue 13 provided to the cope 2 and is cast through a vertical runner 12 and a horizontal runner 11 into the pouring spaces 14 in the casting mold 1 constituted of the cope 2 and drag 3 in the stage of casting the molten metal into the spaces 14. The cutter 29 of a device 20 for removing the wall of the sprue is lowered into the sprue 13 is moved to the right to break away part of the wall 15 of the sprue 13 and to expel the molten metal in the sprue 13 into a vessel 33 through a spout member 30 before the molten metal in the sprue 13 solidifies. The funnel-shaped solidified metal forming the sprue does not exist in the stage of separating the cope 2 from the drag and therefore the cope 2 is easily separated from the casting in the drag 3 without collapse. The molding sand stuck to and carried away by the casting is extremely decreased in the stage of taking the casting out of the drag.

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